

19-7788



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PC250-300
Job Sheet 200692



Part No: PC250-300

Part Name: Load Beam



Part Weight: 0 lbs

Job Created: 9/16/19

Due Date: 11/1/19

Type: SOLD

Note: DWG PC250-300 REV:1 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Job Qty: 3 pcs

Status: New

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description: Order 19525

P.T.O.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Machining - Issue SN	3 pcs	11/1/19	11/1/19	0.00	0.00	NV5000 - 1		J.C. 10-10-19
							NV5000 - 2		J.C. 10-10-19
120	NV5000 - 1 - B4B	3 pcs	11/1/19	11/1/19	0.50	3.00	QC 2 - 1		
130	QC 2	3 pcs	11/1/19	11/1/19	0.00	0.00	QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C. 10-11-19
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

68-6
9-8
6
DAS



Container No: S226724



Part: PC250-300

Job No: 200692

Serial No/Batch: S226724

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/25/19

Plex 10/25/19 3:45 PM dart.charest-lacombe.ju.

				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140	QC 8	3 pcs	11/1/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
142	Outsource - 1 - Heat Treat	3 pcs	11/1/19		ATL002-VC 8
150	Packaging 2-1 - Receive - B4B	3 pcs	11/1/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B

19/11/06

2019-11-08

DP NOV 20 2019

					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
158	QC 6	3 pcs	11/1/19	0.00 0.00	QC 6 - 9	10 12.11.26
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
159	Packaging 3-1 - Stock - B4B	3 pcs	11/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160	QC 21 - SA	3 pcs	11/1/19	0.00 0.00	QC 21 - SA - 21	GA ALAIN
					QC 21 - SA - 70	21
					QC 21 - SA - 53	3-82

Part Op 120 - (MORI SEIKI VERTICAL MACHINE #1) Cut Blanks at 14.63" 1-Machine as per folio FB930 FOLIO REV:
 Descriptions: AA DWG REV: 1 2-Machine engrave 3-Debur

130 - QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

142 - 1-Issue P/O; 45259 Heat treat RC 53-56 2-Bead blast 3-Material type; 4140 4-Apply LPS-3 to ALL steel
 parts 5-Certificate of Conformity is required

- 150 - (Identify as per dwg & Stock Location: _____) Identify and Stock
 158 - (QC6- All purchased or subcontracted products)
 159 - Identify and stock: _____
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-2.250X8.000	AISI 4140 Steel Sheet 2.250" x 8.000" Cut to 14.750"	3 Ea (1 ea)	110-Machining - Issue SN	5219158

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Machining - Issue SN	MT-4140-S-2.250X8.000	3	3	0

Part Specifications

Specifications could not be found.

Plex 10/25/19 3:45 PM dart.charest-lacombe.julien



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045059**



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045059

PO Date: 11/8/19

Due Date: 11/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200692	PC250-300	PC250-300 Rev 1	Load Beam 1-Issue P/O Heat treat RC 53-56 2-Bead blast 3-Material type 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	3 pcs	0 pcs	3 pcs	\$64.5133/pcs	\$193.54
2	202969	RBE117-12020-W14	RBE117-12020-W14 Rev B	Mounting Ring Input Main Gear Box (Outsource process - Heat Treat) 1-Issue P/O RC 40-45 2-Bead blast 3. Material 4140 -Apply LPS-3 to ALL steel parts 4-Certificate of Conformity is required	Firmed	-	11/19/19	8 pcs	0 pcs	8 pcs	\$16.415/pcs	\$131.32
Line Item Note: **4 blanks sent; will be cut into 2 = 8 pcs												
3	200691	PC250-700	PC250-700 Rev 2	Lever Arm 1-Issue P/O RC 42-44 2-Bead blast 3-Material type 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	4 pcs	0 pcs	4 pcs	\$43.75/pcs	\$175.00

Plex 11/15/19 10:14 AM Dart.Guerin.Kimberley



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PURCHASE ORDER

POHB045059



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	201020	RBE117-15004W6-17	RBE117-15004W6 Rev B	Ring 1-Issue P/O RC 48-52 2-Bead blast 3-Material type O1 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	7 pcs	0 pcs	7 pcs	\$11.4285/pcs	\$80.00
5	200895	RBE105-14181W4-15	RBE105-14181W4 Rev C	Base 1-Issue P/O RC 48-52 2-Bead blast 3-Material type O1 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	6 pcs	0 pcs	6 pcs	\$13.3333/pcs	\$80.00
6	201019	RBE117-15004W6-15	RBE117-15004W6 Rev B	Spacer Ring 1-Issue P/O RC 48-52 2-Bead blast 3-Material type O1 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	7 pcs	0 pcs	7 pcs	\$11.4285/pcs	\$80.00
7	200890	PC250-530	PC250-530A Rev 1	Shaft 1-Issue P/O Heat treat RC 44-46 2-Bead blast 3-Apply LPS-3 rust inhibitor 4-Material type 4140 5-Certificate of Conformity is required	Firmed	-	11/19/19	3 pcs	0 pcs	3 pcs	\$26.6666/pcs	\$80.00
8	201077	PC250-610	PC250-610 A	Pin 1-Issue; P/O RC 42-44 2-Bead blast 3-Material type 4140 - lightly oil parts after bead blast 4- Certificate of Conformity is required	Firmed	-	11/19/19	20 pcs	0 pcs	20 pcs	\$4.00/pcs	\$80.00
Grand Total:											\$899.86	



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PURCHASE ORDER
POHB045059



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/15/19 10:14 AM Dart.Guerin.Kimberley

Atlantic Heat Treating (2001) Ltd

Order No.: 171983

Ship Date: 14/11/2019

Shipping Ticket

Sold To:

1448

DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To:

168774

DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB045059				

Quantity	Part No. / Part Name / Part Description	Pounds
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3 PCS MATERIAL 4140
ANNEAL AND HEAT TREAT TO 53-56RC
BEAD BLAST, C OF C, PRT# PC250-300, JOB# 200692

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped: 3

Pounds Shipped: 46.00

RECEIVED

NOV 20 2019

DART AEROSPACE LTD.AB
SSRL

11-18-19

Order No.: 171983

Shipped Complete

Quantity Shipped: 3.00

Received By:

Date:

Pounds Shipped: 46.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 11/14/2019

Certification

Date: 19/11/2019

Entry Date: 14/11/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB045059

Packing List No.:

HAWKESBURY ON K6A 1K7

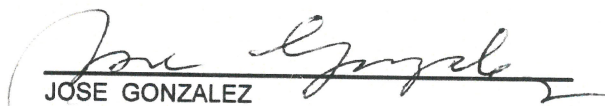
Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds			
3	3 PCS MATERIAL 4140 ANNEAL AND HEAT TREAT TO 53-56RC BEAD BLAST, C OF C, PRT# PC250-300, JOB# 200692	46			
Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements					

Customer Requirements:**Results:**Harden ROCKWE 53. 56. 55. TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 55RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE FOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


JOSE GONZALEZ
QUALITY CONTROL

ATLANTIC HEAT TREATING 2001 LTD

